



DEPARTMENT OF THE NAVY
HEADQUARTERS UNITED STATES MARINE CORPS
WASHINGTON, D. C 20380

NORMAL

MI-00438B-12/1
12 Apr 1979

U.S. MARINE CORPS MODIFICATION INSTRUCTION

INSTALLATION OF RETAINING SCREWS

HEATER, IMMERSION, LIQUID FUEL

1. Purpose. To provide instructions for installing retaining screws on the heating and air-conditioning pipe assembly of the Liquid Fuel Immersion Heater.
2. Applicability. Immersion heaters will be inspected and those that are found to have welds that are not holding will be modified in accordance with this MI.
3. Information. Reports reveal the spot welding of the heating and air-conditioning pipe does not hold, and the stove pipe will fall off during operation.

4. Major Item Affected

<u>Description</u>	<u>NSN</u>	<u>TAM No.</u>	<u>I.D. No.</u>
HEATER, Immersion, Liquid Fuel	4540-00-469-6593	C4980	00438B

5. Components Affected

<u>Description</u>	<u>NSN</u>	<u>PN</u>
PIPE, Air-Conditioning and Heating	4520-00-277-8339	57026-1
COLLAR ASSEMBLY	4540-00-740-0125	M5000

6. Materiel Required

<u>Description</u>	<u>NSN</u>	<u>PN</u>	<u>Qty.</u>
SCREW, Machine, Fillister Head, Slotted, UNC-2A	5305-00-543-4302	MS35265-79	4
NUT, Plain, Hexagon, Carbon Steel, UNC-2B	5310-00-761-6882	MS51967-2	4

7. Skilled and Time Required. Engineer Equipment Mechanic (MOS 1341), 0.5 hours.

8. Modification Procedures

- a. Mount the one section of the air-conditioning and heating pipe to the collar assembly.
- b. Drill four 1/4-inch-diameter holes as shown in figure 1.

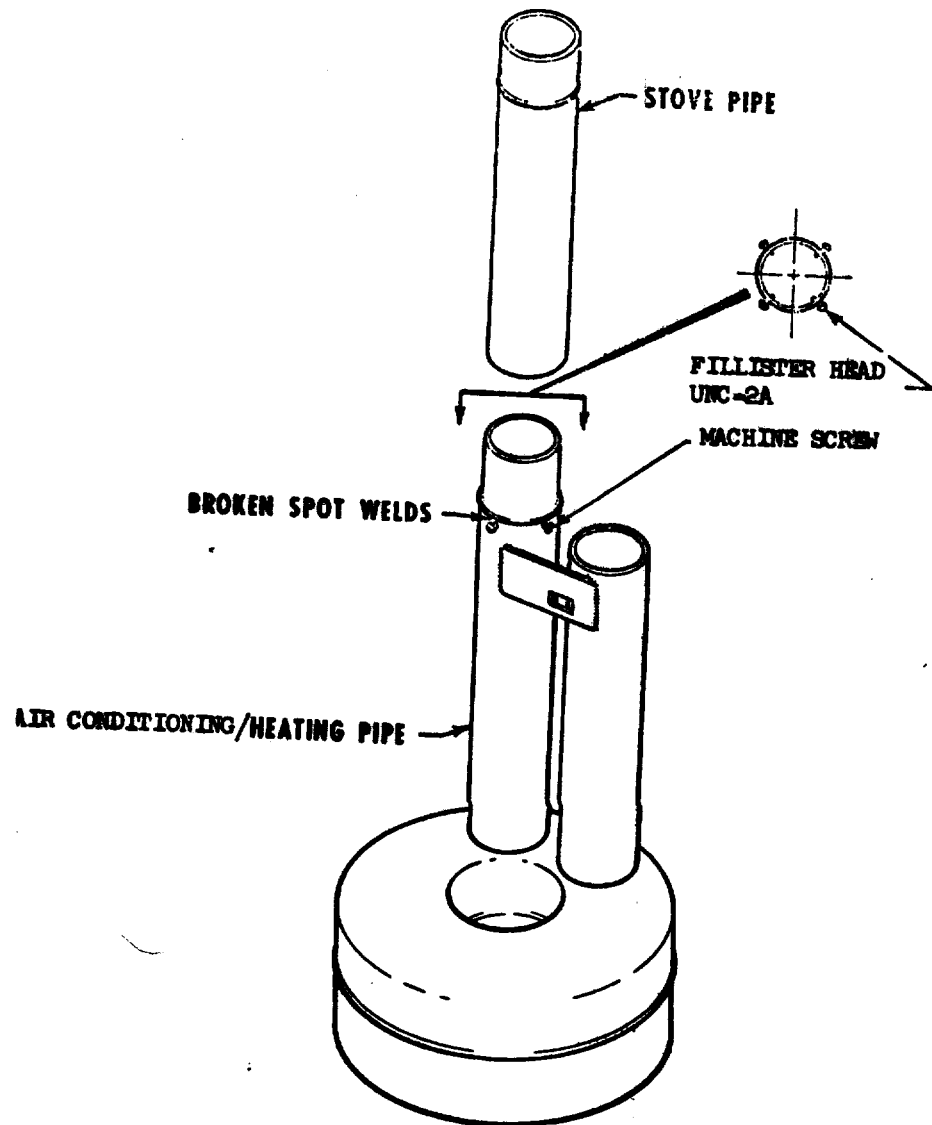
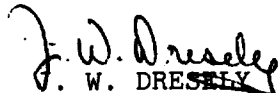


Figure 1. Location for Drilling and Positioning of Screws

c. Position Machine Screws (NSN 5305-00-543-4302) and tighten with
Hexagon Nuts (NSN 5310-00-761-6882).

BY DIRECTION OF THE COMMANDANT OF THE MARINE CORPS

OFFICIAL


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